

WORK ORDER 2010-32

Date opened: 14 October 2010

Project: Quick Release Cargo Basket Assembly
Type: Robinson R44 Series

Batch Quantity: 1 Sets RH Mounting Beams
4 Sets LH Mounting Beams
2 Sets RH Attachment Fittings
2 Sets LH Attachment Fittings

Approval: SH10-48
Drawing List: DCL906-11

Fabrication and Assembly Drawing(s)	Description
90630, Rev. 0	Forward Beam Ass'y
90631, Rev. 0	Aft Beam Ass'y
90620, Rev. 0	Attachment Fittings

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: _____

Welder Signature: _____ Date: _____

Jeff Clarke
Inspector Signature: _____ Date: 19 Nov 10

Drawing: 90630 Revision 0
 Assembly: 90630-01 Forward Beam Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
1 Total	90630-01-01	RH Forward Beam Assembly			
4 Total	90630-01-02	LH Forward Beam Assembly			
1	90630-02	Tube	304 Stainless, 1x2x0.065 tube	10096	
1	90630-03-01	RH Down Tube	304 4130 Steel, 1x1x0.065 tube	10096	
1	90630-03-02	LH Down Tube	304 4130 Steel, 1x1x0.065 tube	10096	
1	90630-04	Support	304 Stainless, 3/4" x 0.065 tube	10083	
2	90630-05	Ring	304 Stainless, 7/8" x 0.065 tube	10114	
1	90630-06	Bushing	304 Stainless, 5/8" x 0.120 tube	8011	
1	90630-07	Cap	321 Stainless, 0.032" Sheet	3021	
1	90630-08	Cap	321 Stainless, 0.032" Sheet	3021	
1	90630-09	Cap	321 Stainless, 0.032" Sheet	3021	
2	90630-11-01	RH Hook	304 Stainless, 2x1x0.12 tube	8048	
2	90630-11-02	LH Hook	304 Stainless, 2x1x0.12 tube	8048	
1	90630-12	Hose	Commercial 3/4" Heater Hose	COMMERCIAL	
1	90630-13	Gusset	304 Stainless, 1x2x0.065 tube	10096	
1	69830-16	Strap	304 Stainless, 0.105" Sheet	10036	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Powder Coat	Drawing 90630			
Final Inspection	Drawing 90630			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 90631 Revision 0
 Assembly: 90631-01 Aft Beam Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	90631-01-00	Aft Beam Assembly			
1	90631-02	Tube	304 Stainless, 1x2x0.0.065 tube	10096	
1	90631-03	Down Tube	304 Stainless, 1x2x0.0.065 tube	10096	
1	90630-04	Support	304 Stainless, 3/4" x 0.065 tube	10083	
2	90630-05	Ring	304 Stainless, 7/8" x 0.065 tube	10114	
1	90630-06	Bushing	304 Stainless, 5/8" x 0.120 tube	9011	
1	90630-07	Cap	321 Stainless, 0.032" Sheet	3021	
1	90630-08	Cap	321 Stainless, 0.032" Sheet	3021	
1	90630-09	Cap	321 Stainless, 0.032" Sheet	3021	
2	90631-10	Pad	304 Stainless, 1x0.125 Bar	10037	
1	90630-12	Hose	Commercial 3/4" Heater Hose	COMMERCIAL	
1	69830-16	Strap	304 Stainless, 0.105" Sheet	10036	
1	69830-17	Block	304 Stainless, 1/4" Sqr. Rod	9011	
1	69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	10083	
1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	10086	
1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	10086	
1	69830-23	Spring	15mm x 70 mm Spring	9091	
1	#10-32	Screw	Stainless Steel, Commercial	9053	
1	MS21044C3	Nut		9056	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Powder Coat	Drawing 90631			
Final Inspection	Drawing 90631			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.


Drawing: 90620 Revision 3
 Assembly: 90620-01, -02 Clamp Ass'y

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
8 Total	90620-01-00	Clamp Assembly (Close)			
1	90620-03	Clamp (Close)	6061-T6 Aluminum, 4 x 1 bar	10032	
4 Total	90620-02-01	Clamp Assembly (Far, RH)			
1	90620-04-01	Clamp (Close)	6061-T6 Aluminum, 4 x 1 bar	10032	
4 Total	90620-02-02	Clamp Assembly (Far, LH)			
1	90620-04-02	Clamp (Close)	6061-T6 Aluminum, 4 x 1 bar	10032	
Parts Common to all Assemblies					
1	90620-05	Strap	6061-T6 Aluminum, 4 x 1 bar	10032	
1	AN4-12A	Bolt		10049	
1	AN960-416	Washer		↓	
1	MS21042L4	Nut		10068	
1	FT4F-175H	T Bolt		10065	
1	BH000142A4	Self Aligning Nut			


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 90620			JK.

Tag incomplete parts with Work Order # when stored between processes.


Tag complete parts / assemblies with Release Tag prior to storage.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7				5. Work Order/Contract/Invoice WO2010-32	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	RH Forward Beam	90630-01-01	1	N/A	New
2.	Aft Beam	90631-01-00	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mm/yyyy) 07 Dec 2010		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

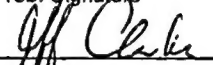
HORIZON

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2010-32
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Clamp Ass'y (close)	90620-01-00	2	N/A	New
2.	Clamp Ass'y (RH, Far)	90620-02-01	2		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 	13c. Approved Organization Number AMF 73-04		14b. Signature	14c. Approved Organization Number	
13d. Name Jeff Clarke	13e. Date (dd/mm/yyyy) 07 Dec 2010		14d. Name	14e. Date (dd/mm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					


16021200

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2010-32
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	LH Forward Beam	90630-01-02	1	N/A	New
2.	Aft Beam	90631-01-00	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations .		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 02 Feb 2011		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
<p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					


1421 TOW CAR 1


1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2010-32
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Clamp Ass'y (close)	90620-01-00	2	N/A	New
2.	Clamp Ass'y (LH, Far)	90620-02-02	2		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature		13c. Approved Organization Number	14b. Signature		14c. Approved Organization Number
		AMF 73-04			
13d. Name		13e. Date (dd/mm/yyyy)	14d. Name		14e. Date (dd/mm/yyyy)
Jeff Clarke		02 Feb 2011			
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

HELIX TOW CART


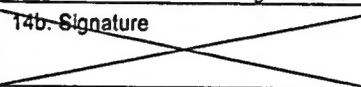
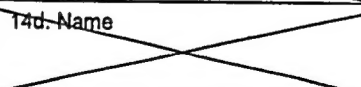
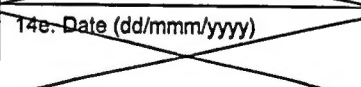
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6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Clamp Ass'y (close)	90620-01-00	2	N/A	New
2.	Clamp Ass'y (RH, Far)	90620-02-01	2		
12. Remarks					
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13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mm/yyyy) 19 Dec 2011		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
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AERO AIR

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4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2010-32
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	LH Forward Beam	90630-01-02	1	N/A	New
2.	Aft Beam	90631-01-00	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 31 May 2011		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

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6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
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13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature 14c. Approved Organization Number	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 25 Feb 2011		14d. Name 14e. Date (dd/mmm/yyyy)	
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

CAN-22

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2010-32
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	LH Forward Beam	90630-01-02	1	N/A	New
2.	Aft Beam	90631-01-00	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			<input type="checkbox"/> Other regulation specified in block 12		
<input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature		13c. Approved Organization Number		14b. Signature	
		AMF 73-04			
13d. Name		13e. Date (dd/mmm/yyyy)		14c. Approved Organization Number	
Jeff Clarke		23 Feb 2011			
14d. Name		14e. Date (dd/mmm/yyyy)			
Installer Responsibilities					
This certificate does not constitute authority to install.					
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.					
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Held Down after